

Date: Tuesday, 7/1/2008 2:35:08 PM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 40199	
Estimate Number : 10534	
P.O. Number :	Part Number : D2574
This Issue : 7/1/2008 S.O. No. :	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 39809	Material :
Written By :	Due Date : 7/23/2008 Qty: <sup>10</sup> / <sub>6</sub> Um: Each
Checked & Approved By : <u>08.07.01</u>	
Comment : Est Rev: 1 As Per RevE 06-01-27 JLM	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2574  
Ensure that grain is along 5.00" length  
Batch No: B34874

J.F. 08/08/20 (10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 40199 Double check by: 88

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

J.F. / PM 08/08/22

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2573 & D2574

J.F. / PM 08/08/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / PM 08/08/22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 7/1/2008 2:35:08 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 40199

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 08/08/23

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SP 08-08-25 X10

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40  
325°F  
12:10

M-6 08/08/25

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-25 X10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

8/8/25 SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



W 08/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	40199
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.439"	.440	.440	.440		
B	1.745	1.755		1.749"	1.749	1.750	1.750		
C	3.495	3.505		3.500"	3.500	3.500	3.500		
D	1.745	1.755		1.749"	1.749	1.750	1.750		
E	7.990	8.010		8.005"	8.000	8.000	8.000		
F	0.490	0.510		.503"	.501	.506	.506		
G	0.257	0.262		0.258"	0.258"	0.258"	.260		
H	0.375	0.380		0.377"	0.377"	0.377"	.378		
I	0.490	0.510		.504"	.503"	.503"	.501		
J	1.174	1.184		1.179"	1.179"	1.179"	1.179		
K	0.558	0.578		.571"	.568"	.570"	.570		
L	1.174	1.184		1.179"	1.179"	1.179"	1.179		
M	1.365	1.375		1.370"	1.370"	1.370"	1.370		
N	2.495	2.505		2.500"	2.500	2.500	2.500		
O	4.119	4.129		4.123"	4.123"	4.123"	4.123		
P	0.115	0.135		.125"	.126"	.126"	.127		
Q	0.115	0.135		.135"	.135"	.135"	.135		
R	0.240	0.260		.251"	.252"	.252"	.257		
S	0.115	0.135		.125"	.125"	.126"	.125		
T	0.178	0.198		R.188"	R.188"	R.188"	.188		
U	3.210	3.250		3.230"	3.230"	3.230"	3.228		
V	0.230	0.250		.237"	.236"	.243"	.240		
W	0.115	0.135		.129"	.132	.132	.134		
X	0.307	0.312		.310"	.309	.310	.310		
Y	0.760	0.765		.761"	.761	.761	.762		
Z	0.352	0.372		.367"	.364	.365	.366		
AA	0.470	0.530		R.500"	R.500"	R.500"	.500		
AB	0.615	0.635		.629"	.626	.628	.627		
AC	0.053	0.073		.063"	.063"	.063"	.063		
AD	0.240	0.260		.251"	.250"	.250"	.249		
AE	1.500	1.520		1.509"	1.510"	1.510"	1.510		
AF	0.115	0.135		.135"	.135"	.135"	.135		
AG	0.240	0.280		.280"	.280"	.280"	.276		
AH	0.240	0.260		.251"	.250"	.250"	.248		
AI	2.000	2.020		2.000"	2.000"	2.000"	2.001		
AJ	0.023	0.043		.033"	.033"	.033"	.033		
Accept/Reject									

Measured by:	J.F. / 10ml
Date:	28/08/20

Audited by:	J.F.
Date:	08/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	40199
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b>	D2574
<b>Inspection Dwg:</b> D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.000		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.503	.501		
G	0.257	0.262		.260	.266	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.502	.501	.502		
J	1.174	1.184		1.179	1.180	1.179	1.179		
K	0.558	0.578		.576	.570	.569	.571		
L	1.174	1.184		1.179	1.180	1.179	1.179		
M	1.365	1.375		1.370	1.369	1.369	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.122	4.123	4.123		
P	0.115	0.135		.126	.126	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.127	.127	.127	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.230	3.230	3.229		
V	0.230	0.250		.238	.240	.238	.241		
W	0.115	0.135		.131	.133	.133	.133		
X	0.307	0.312		.310	.309	.309	.309		
Y	0.760	0.765		.761	.760	.760	.766		
Z	0.352	0.372		.365	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.626	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.246	.246		
AE	1.500	1.520		1.511	1.510	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.276	.270	.268	.268		
AH	0.240	0.260		.249	.250	.249	.249		
AI	2.000	2.020		2.002	2.002	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	amf
Date:	08/08/22

Audited by:	S.P.
Date:	08/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 46199
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>


Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

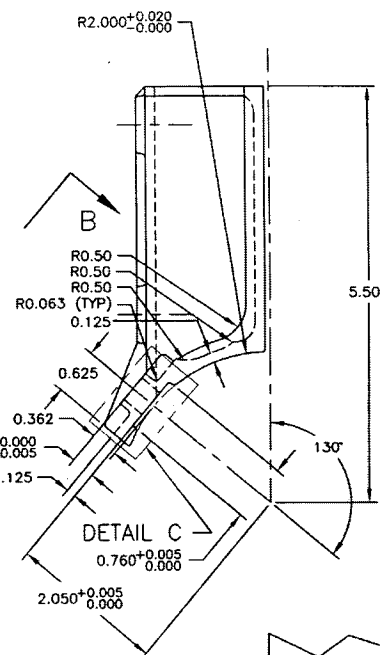
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.506	3.506				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.006	8.006				
F	0.490	0.510		.502	.501				
G	0.257	0.262		.266	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.501	.501				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.571	.570				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.376	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.126	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.251				
S	0.115	0.135		.128	.123				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.229	3.228				
V	0.230	0.250		.238	.240				
W	0.115	0.135		.133	.132				
X	0.307	0.312		.309	.309				
Y	0.760	0.765		.766	.760				
Z	0.352	0.372		.367	.365				
AA	0.470	0.530		.506	.500				
AB	0.615	0.635		.629	.627				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.247	.247				
AE	1.500	1.520		1.509	1.510				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.249	.249				
AI	2.000	2.020		2.006	2.001				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>cmf</i>
Date: 08/08/22





Audited by: <i>28</i>
Date: 08/08/22

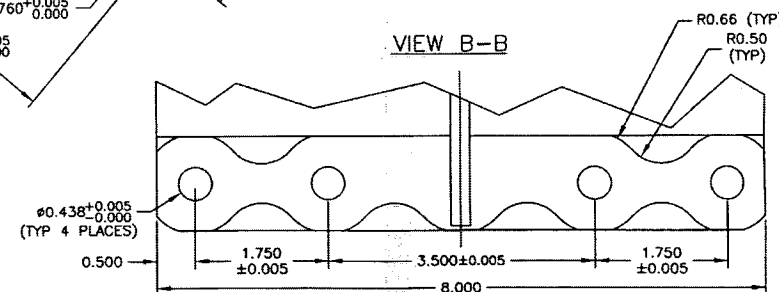
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>28</i>

05.12.06 






MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-0003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



DETAIL C  
SCALE 2:1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40199

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
DRAWN BY		
DS	PH	
CHECKED 	APPROVED 	DRAWING NO. D2574
DATE 05.07.13		TITLE INNER AFT SADDLE